

Work Order ID 84871

May-29-12 1:00:23 PM

84871

Page 1

Item ID: D3564-11

Revision ID:

Item Name: Wearshoe

Start Date: 29/05/2012 Start Qty: 25.00

Required Date: 16/07/2012 Req'd Qty: 25.00

Reference:

Approvals: Process Plan: *mu*

QC:

Date: *16/07/12* Tooling:

Date: SPC (Y/N):

Cust Item ID:

Customer:

N9000040100

Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Number Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev ID

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

304.063

1- Cut as per Dwg D3564 ***** (D3564-11) ***** Dwg Rev: *D* Prog
Rev: *D* 2-Debur if necessary

B12-6-3

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-6-3

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

30

m 12 06 04

split

~~*25*~~

~~*25*~~

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 84871

May-29-12 1:00:23 PM

84871

Page 2

Item ID: D3564-11

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearshoe

Start Date: 29/05/2012 Start Qty: 25.00

25

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 25.00

25

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

NC BRAKE

0.00

130

Brake NC

Memo

0.00

Brake NC

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179

30

8B
12/06/07

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

6/17/06/10/02

100%
(30)

150

Large Fab

0.00

150

Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat
Weld hardcoat as per Dwg D3437

(X12)

MAL

12/06/15

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Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

Quality Control

8/26/12

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

8/26/12

(+12)

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

180

Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:00 OVEN TEMPERATURE:

FINISH TIME:

3200F

8:30

12X

M/L
12/06/12

M121279

W/O:		WORK ORDER CHANGES					
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Page 4

Item ID: D3564-11

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearshoe

Stop ***NS2***

Start Date: 29/05/2012 Start Qty: 25.00

25

Required Date: 16/07/2012 Req'd Qty: 25.00

25

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: **F-PZ**

0.00

200

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

Handwritten notes:
12 φ
12X φ
12/06/19
M-2
12/06/19
12/06/19

W/O:		WORK ORDER CHANGES					
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Picklist Print

May-29-12 1:00:27 PM

Page 1

Work Order ID: 84871

Parent Item: D3564-11

Parent Item Name: Wearshoe

84871

D3564-11

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
 IPP Rev:D Comments revised on Step 5.6 per B44656 09-02-06 KJ
 Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	271.9729	1.41	37.10526			
**													

M304S16GA

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

271.972

121626

143.972

121889

128

121626

(3)

B12-6-14

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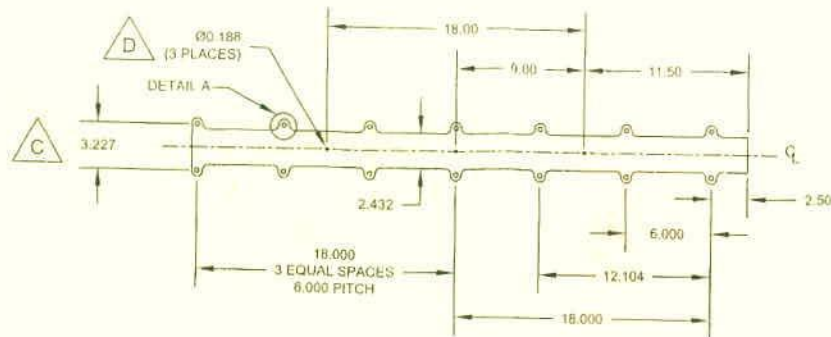
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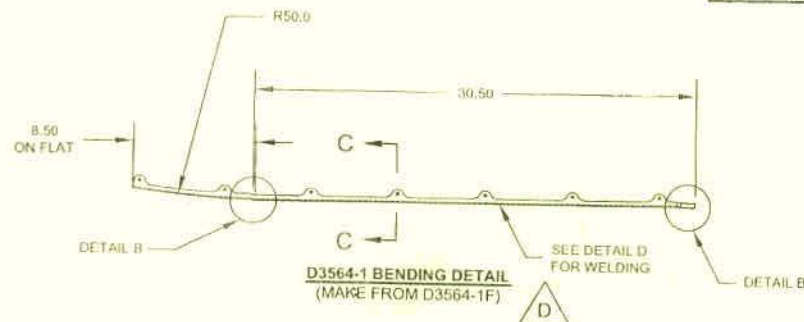
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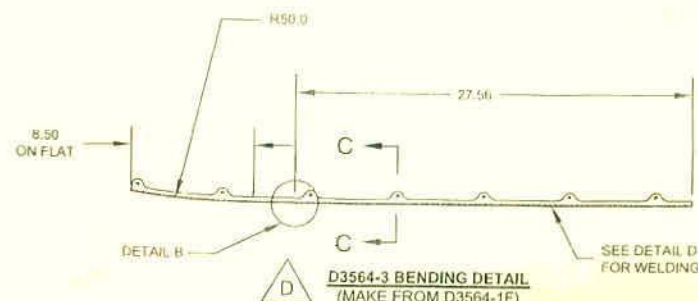
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

UNDER REVIEW

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A6: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.21
A	NEW ISSUE	PH	06.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3564
TITLE WEARSHOE
REV. D
SHEET 1 OF 3
SCALE 1:1

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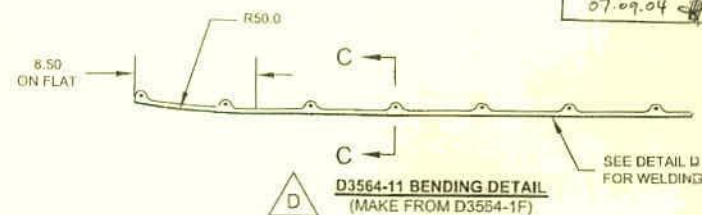
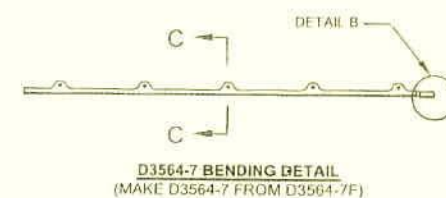
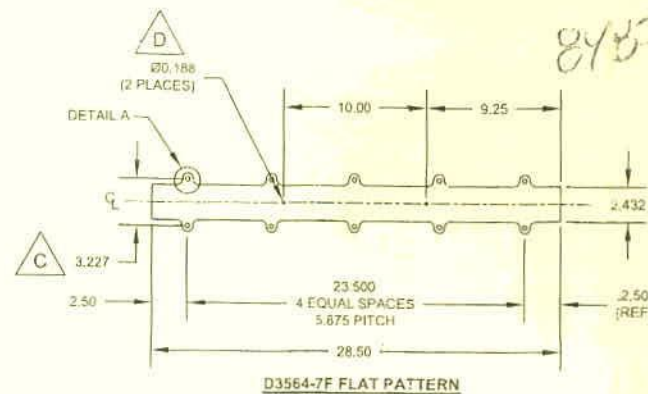
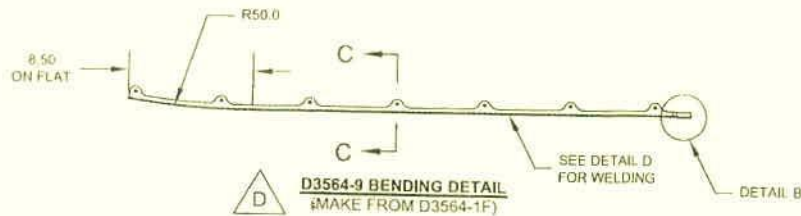
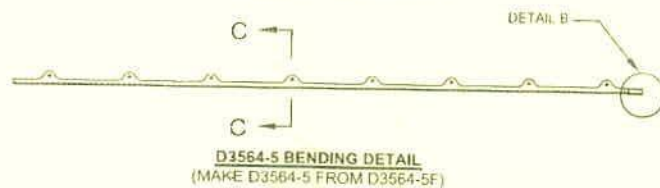
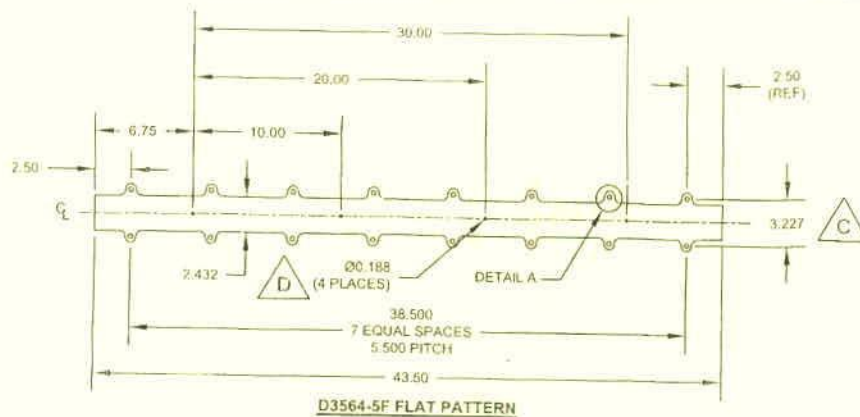
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NOTE: Date & initial all entries



UNDER REVIEW
OK 11/29

RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD	

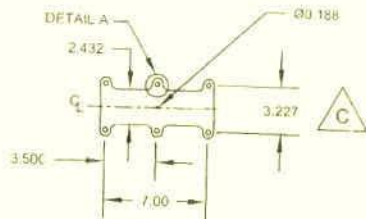
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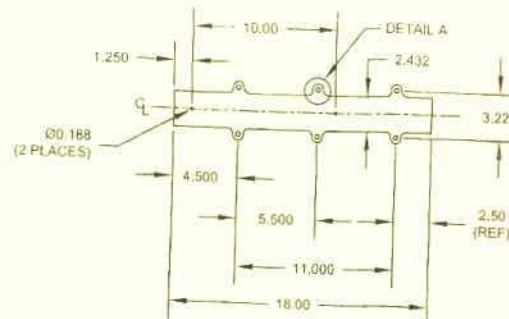
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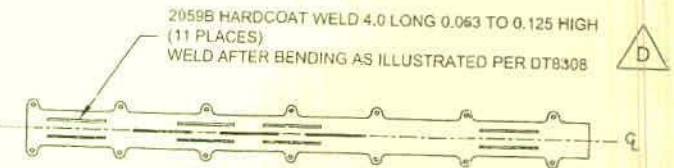
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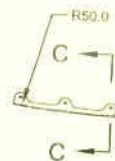
D3564-13F FLAT PATTERN



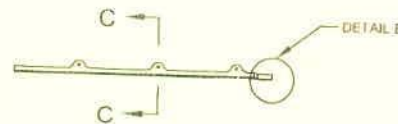
D3564-15F FLAT PATTERN



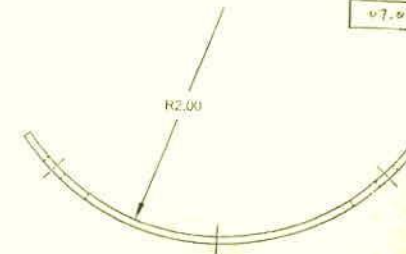
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



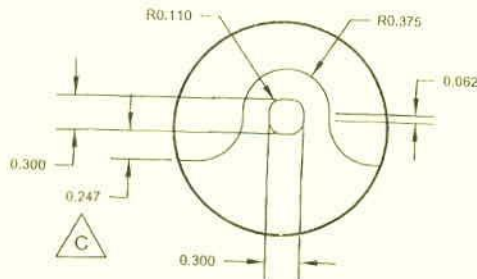
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



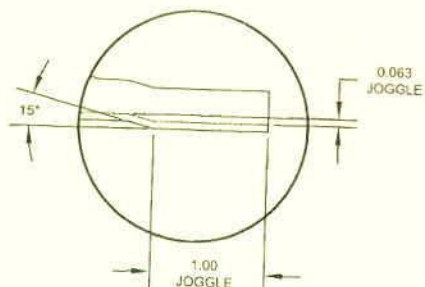
SECTION C-C
SCALE 1:1

RELEASED
07.09.04

UNDER REVIEW
OK 07.11.28



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
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